

Work Order ID 77576

77576

Page 1

Tuesday, December 13, 2011 2:40:44 PM

Item ID: D3912-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Eyebolt Receiver Assembly
 Start Date: 12/13/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/5/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: *12-13-11* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3912	B								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1-Assemble D3912-1/-3/-5 and install rivets as per dwg TRIM RIVETS 1.250" LONG								
	2- Install helical, spring plunger and spring pin lanyard assy as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

[Signature] 12/01/10 (4)

[Signature] 12/01/10 (4)

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location. <u>ST 507</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

(4X) SP 12-01-12

12/1/16 JF
 MF 12-01-12

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Picklist Print

Tuesday, December 13, 2011 2:40:53 PM

Page 1

Work Order ID: 77576

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Parent Item: D3912-041

D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R		Purchased	No				Each	215.0000		4			
NAS1149C0663R									**				
Washer													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST297				215					
				110139				15					
				116893				200					
D3912-1		Manufactured	No			100	Each	5.0000	1	4			
D3912-1									**				
Eyebolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				5					
				69593				5					
D3912-3		Manufactured	No			100	Each	3.0000	2	8			
D3912-3									**				
Eyebolt Block													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST091				3					
				69539				2					
				70424				1					

Handwritten notes and signatures:
 - Signature: B12/01/10
 - Signature: B12/01/10
 - Signature: B12/01/10
 - Stamp: B76962 (8x)

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Page 2

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D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 12/13/2011

Required Date: 1/5/2012

Start Qty: 4.00

Required Qty: 4.00

D3912-5 Manufactured No

100 Each 19.0000 2 8

D3912-5

Eyebolt Plate

**

Location Loc Qty Loc Code

ST091 19

76293 4

76961 15

Each 17.0000

**

D3801-1 Manufactured No

D3801-1

Hand Retractable Spring Plunger

Location Loc Qty Loc Code

ST083 17

68379 2

75178 15

100 Each 174.0000 8 32

**

MS20615-4M20 Purchased No

MS20615-4M20

RIVET

Location Loc Qty Loc Code

GA 174

117071 30

118571 14

119546 30

119638 100

Each 20.0000

**

MS21209-F615 Purchased No

MS21209-F615

Heli-Coil

Location Loc Qty Loc Code

ST304 20

108170 11

108244 9

12/01/10

12/01/10

12/01/10

12/01/10

1120072 22

Tuesday, December 13, 2011 2:40:53 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

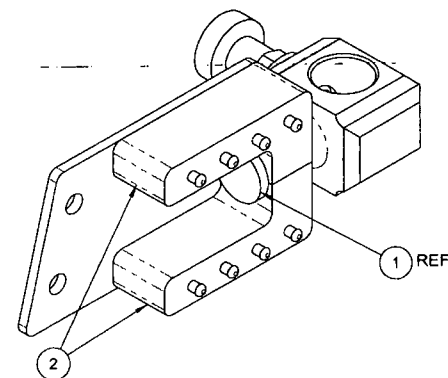
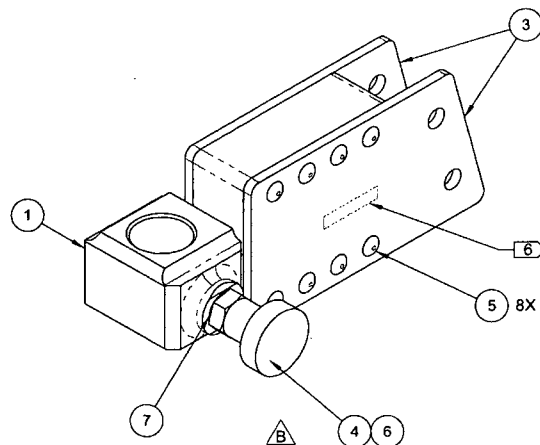
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20615-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77374

11-12-13

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>		
DRAWN	<i>ALS</i>		
CHECKED	<i>ALS</i>		
MFG. APPR.	<i>ALS</i>		
APPROVED	<i>ALS</i>		
DE APPR.	<i>ALS</i>		
DATE	10.06.28		

RELEASED
2010-07-16

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3912** REV. B
SHEET 1 OF 3
TITLE **EYEBOLT RECEIVER ASSY** SCALE NTS

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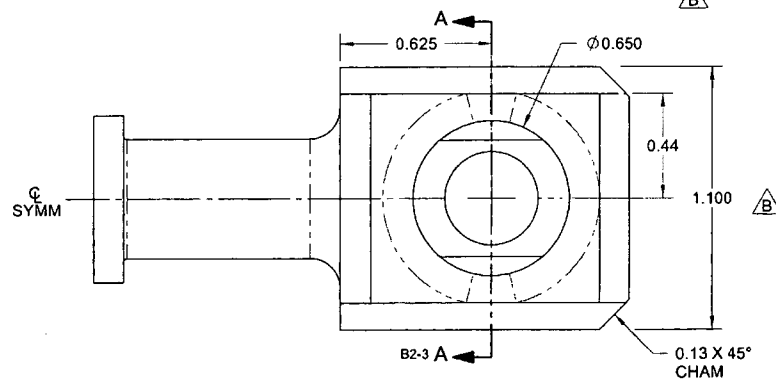
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2010-07-16

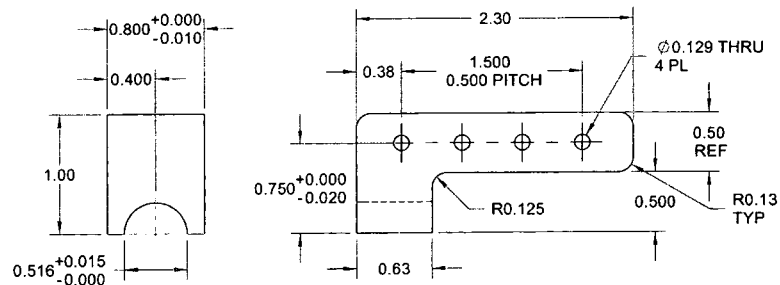
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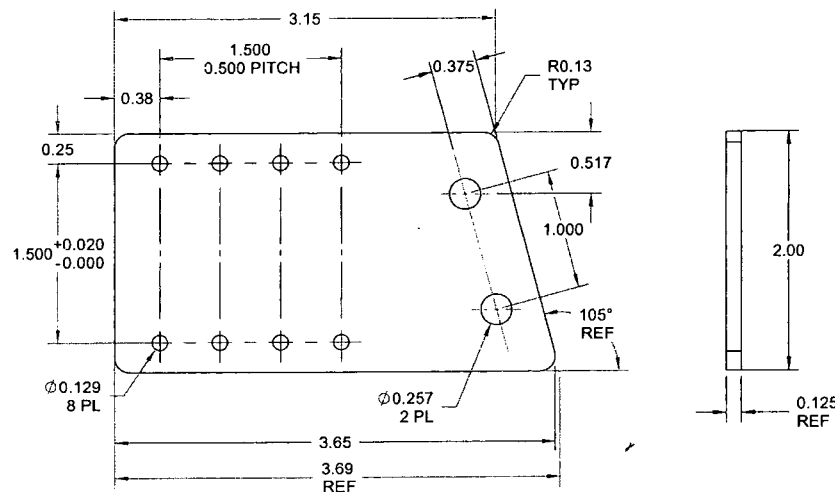
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D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
REF DART SPEC M303S11GA OR M304S11GA

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

77576

RELEASED
2010-07-16
JMD

DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	J/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J/S	DRAWING NO.	REV. B
MFG. APPR.	J/S	D3912	SHEET 3 OF 3
APPROVED	J/S	TITLE	SCALE
DE APPR.	J/S	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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